

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59244

Friday, May 28, 2010 9:52:02 AM



Page 2

Item ID: D3698-1

Accept



Setup Start



Revision ID:

Item Name: Support Angle

Stop



Start Date: 5/27/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Bend 105 deg. angle as per Dwg D3698 2-form curve as per dwg D3698 and
verify using template DT9001

Sp 10/6/07

(7)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. 10/6/07

(7)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

7 m. 10/06/07

(7x)

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Start Date: 5/27/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

JL 10/06/07

7

0

Quality Control

170

Identify as per dwg & Stock Location: 24/A

0.00



Packaging

Memo

0.00

Packaging

C/4/8 2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08
ME
10-6-8

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Picklist Print

Friday, May 28, 2010 9:52:07 AM

Page 1

Work Order ID: 59244



Parent Item: D3698-1



Parent Item Name: Support Angle

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
IPP rev:C 08-10-07 revC as per dwg DD verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M6061T6S.032		Purchased	No			100	sf	73.0000	0.4476	2.355789	3.3		



6061-T6 Sheet 0.032"



HB10-6-2

Location

Loc Qty

Loc Code

MAT21

73

110063

3

112763

56

16954

8

18375

6

112763

7

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Dart Aerospace Ltd

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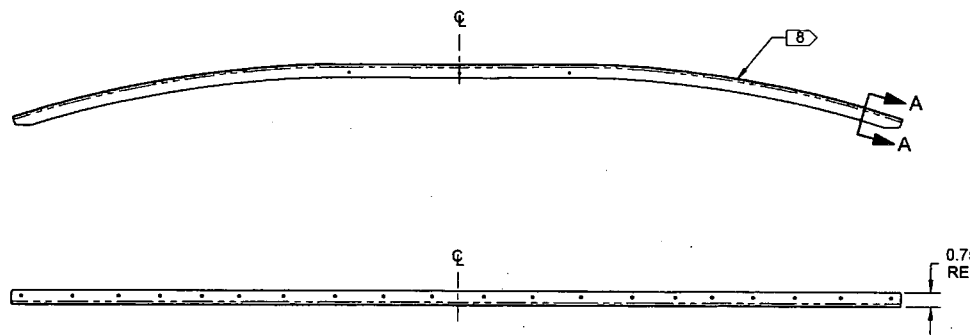
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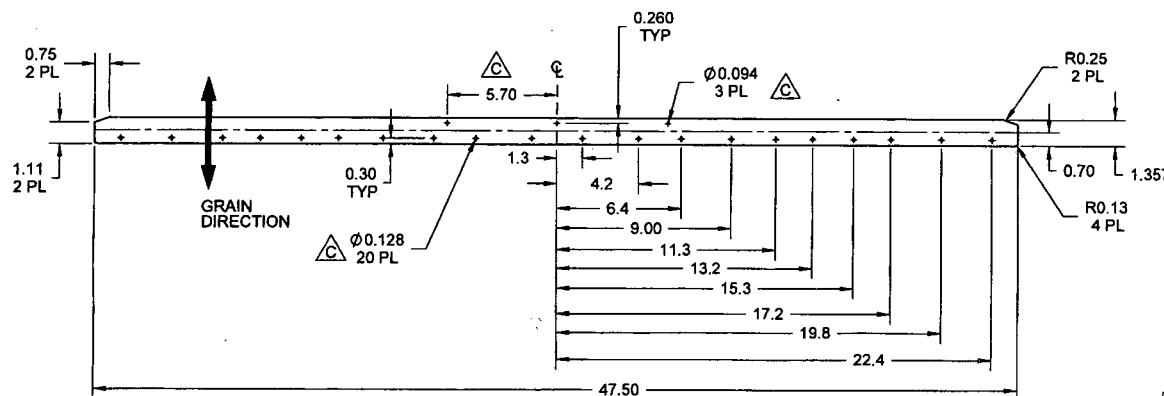
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59244

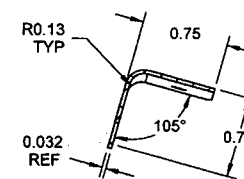
RM-5-28



D3698-1 SUPPORT ANGLE
(MAKE FROM D3698-1F FLAT PATTERN)



D3698-1F FLAT PATTERN



SECTION A-A

RELEASED

- NOTES:**
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK
REF. DART SPEC. M6061T6S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.20 lbs
 - 8) FORM AS PER TEMPLATE DT9001

C	ZONE B5 Ø0.094 HOLE QTY WAS 29 PL. ZONE B6 ADDED "Ø0.128, 20 PL". ZONE B6 5.70 DIMENSION WAS REF.	AJS	08.09.08
B	REMOVE POWDER COAT. ZONE A,B	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3698 REV. C SHEET 1 OF 1 TITLE SUPPORT ANGLE SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DATE 08.09.08	

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